

Date: Thursday, 6/15/2006 1:50:34 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 27585					
Estimate Number	: 10165					
P.O. Number	: N/A			Part Number	: D25255	
This Issue	: 6/15/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2525 REV B	
First Issue	: N/A			Project Number	: N/A	
Previous Run	: N/A			Drawing Revision	: B	
Written By	: <i>See Comment Below</i>			Material	: N/A	
Checked & Approved By	: <i>SD 6/15/06</i>			Due Date	: 6/30/2006	
Comment	Est	C	C	Qty:	65	Um: Each
Comment: Est C C 02.08.22 Make in Cobra KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0750	6061-T6 Round Bar .750"	
		Comment: Qty.: 0.0218 f(s)/Unit Total : 1.4196 f(s) 6061-T6 Round Bar 1.5" <i>FRM</i> Make as per Dwg D2525 and Folio FA261. Material: 5052-H32 (QQ-A-225/7) or 1100 (QQ-A-225/1) or 6061-T6 (QQ-A-225/8) or 6061-T6 (QQ-A-200/8) Ø0.75 Rod(M5052H32R0.750) or (M6061T6R0.750) Batch <i>M100157</i> <i>9m/06/06/28 65</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Dwg D2525 2-Deburr <i>FRM 06/06/28</i> <i>65</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>FRM 06/06/28</i> <i>65</i>	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK <i>J.F. 06/06/29</i> <i>65</i>	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>SAD 06.06.30</i> <i>65</i>	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:50:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27585

Part Number: D25255

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



65

Comment: INSPECT ALODINE

7.0 PACKAGING 1

PACKAGING RESOURCE #1



65

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 47

H.M 06-07-04

8.0 DC

DOCUMENT CONTROL



65

Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/07/05

Job Completion



in 06.07.04

65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

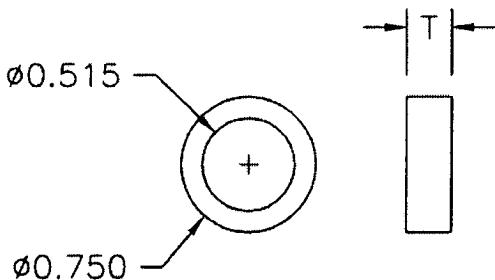
DART

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED H	DRAWING NO. D2525
DATE 99.09.30		TITLE SPACER KIT
		SCALE 1:1
A	95.12.22	NEW ISSUE
B	99.09.30	REVISED MATERIAL

RELEASED

99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
 OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27585

DART AEROSPACE LTD	Work Order:	027525
Description: SPACER	Part Number:	02525-5
Inspection Dwg: 02525, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>Jin</u>	Audited by:	<u>SD</u>	Prototype Approval:	<u>N/A</u>
Date:	06/06/28	Date:	06.06.25	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	